ENGINEERING CHANGE NOTICE

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_	e: 15.04.07 duct No.: D206-667		Job No.:		ENG 6	105	ADF	R Yes/No:	N /	ADR Date:		1	1 - 2 - 1	45 5
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	son for Change:		.)											
Inco	orporated DEO's; Eliminate interference per	DS visit t	o PHI											
Doci	uments Affected:													
	L-D206-667 Rev. Q													
1	07-667-245 Rev. G													
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	PAPERWORK UPDATE			PARTS I	MUST	COMPL	Υ	х	PREVIO	US PAR	TS S	SATISFA	CTORY	
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1	Notify Previous Customers				N				· · · · · · · · · · · · · · · · · · ·					.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
2	Notify Eurocopter France				N									
3	Notify Augusta Westland				N	<u> </u>	t —							
4	Manufacturing Licensing Agreement Upda	te			N	 								
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#	Engineering Ac				Reqd	Resp			Note	s			Cor	nplete
5	Required Documents/Drawings/Item ID's L	Inder Rev	/iew (URF)		N									iproto
7	Update Master Document List (MDL)				Υ	RE-	MDL	-D206-667 F	Rev. Q				12 15	.04.06
8	Update Document Record (DR) Update Product Compatability Matrix				N									
9	Notify TC / FAA of Change (eg. ICA, 8110	2)			N		<u> </u>							
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List Lots

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Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D407-667-205RLC Aft Crosstube - High 407	OFFSHORE FG	,	J2 1/28/2015	1.0000	QC21	CHG008	
-	OFFSHORE FG	124891 (32	2280 1/5/2015	1.0000	QC21	CHG008	

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DQA:	Date:					DART
QA Closed:	Date:	WORK ORDER NO	N-CC	ONFORMANCE / UPDATE	Work Order update only	AEROSPACE
		DISPOSITION		AGAINST	DEPARTMENT/PROCESS	<u> </u>
Work Order:						
		Rework		Skid-tube Cross tube	Water Jet	Engineering
Part No		Scrap		Machining Small Fab	Prod. Eng. Coor.	Quality
		Use-as-is	_ '	Thermoforming Finishing		Other
NCR No.		Suspected Unapproved		Large Fab Composite	Supplier	
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval
	Description Wor	k Order Deviation		Disposition	on	
						Completed By
						Lead hand / Supervisor
					•	Approval Verification
			ļ		·	QC / QA Coordinator
						Approval
Ro	ot Cause	1		FAULT CATEGORY	,	<u> </u>
Environment	No Re-verfication	Pressure/Forced	Г	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending		Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric		BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks		Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs		Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing		Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat		Cut Too Short	Mislabeled	Finish
LOA	Product Improvem	ent Wave/Twist in Tube		Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	ent Marks/Chatter		Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Pro	cess				
Misidentified	Past Due	OTHER:				,

List Lots

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Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
0407-667-205 Aft Crosstube - High 407	Main Warehouse FG094	(32)	4/24/2015	1.0000	QC21	CHG008	
	Main Warehouse FG097	116465 -132	1/5/2015	1.0000	QC21	CHG008	
	Main Warehouse FG097	118408 _ 136	1/5/2015	1.0000	QC21	CHG008	
	Main Warehouse FG097	124538 1321	1/5/2015	1.0000	QC21	CHG008	
	OFFSHORE FG		277 1/5/2015	1.0000	QC21	CHG008	
	OFFSHORE FG	124541 13 2		1.0000	QC21	CHG008	
	OFFSHORE FG	126504 137	2279 1/28/2015	1.0000	QC21	CHG008	
	10		Total:	7.0000			

DQA:	Date:				"DART
QA Closed:	Date:	WORK ORDER NON-C	CONFORMANCE / UPDATE	Work Order update only	AEROSPACE
		DISPOSITION	AGAINS	T DEPARTMENT/PROCESS	A contract of the contract of
Work Order:		-			
Dave Na		Rework	Skid-tube Cross tube	igodot	
Part No.		Scrap	Machining Small Fall	—	
NCR No.		Use-as-is Suspected Unapproved	Thermoforming Finishing Large Fab Composite		
Date :	Is	tep #:	QTY Effective :	от т	MRB (QSI042) Approval
	Description Work	Order Deviation	Dispositi	on	1
	· · · · · · · · · · · · · · · · · · ·				Completed By
					Lead hand / Supervisor
					Approval Verification
					QC / QA Coordinator
					Approval
Ro	ot Cause	T	FAULT CATEGOR	Y	
Environment	No Re-verfication	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvemen	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Proces	ss			
Misidentified	Past Due	OTHER:			

List Lots

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Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
		112865 \^	27		Doe Code		
0407-667-205	Main Warehouse	112865	5/5/2015	1.0000	QC21	CHG008	
Aft Crosstube - High 407	FG		An_				
	Main Warehouse	124541	5/5/2015	1.0000	QC21	CHG008	
	FG		04		4921	22300	
	Main Warehouse	126504 \}	5/5/2015	1.0000	QC21	CHG008	
	FG	. , , ,	2,0,2020	2.3000	QC21	C110000	

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DQA:	Date:		N CO	NICODNANICE / LI	DDATE			DART
QA Closed:	Date:	WORK ORDER NON	N-CO	INFORMANCE / U		ork Order update only		AEROSPACE
Work Order:		DISPOSITION			AGAINST D	EPARTMENT/PROCESS		
Part No.		Rework Scrap Use-as-is		Skid-tube Machining Thermoforming	Cross tube Small Fab Finishing	Water Je Prod. Eng. Coor Rec/Store/Packaging		Engineering Quality Other
NCR No.		Suspected Unapproved		Large Fab	Composite	Supplie	_	
Date :	Sto	ep #:		QTY Effective :			ľ	MRB (QSI042) Approval
	Description Work (Order Deviation		.	Disposition		1	
							T	Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
	Root Cause			FAU	LT CATEGORY		<u> </u>	
Environment		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong
Design	Operator	Bending	\vdash	Set-up	F	Folio/Program		Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	-	BOM/Route	F	Grain		Over/Under tolerand
Equip/Tooling	Supplier	Cracks	-	Broken/Damage/Defect		Weld		Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	-	Inspection Incomplete/U	ngualified	Wrong Stock Pulled		Part Lost/Missing
Material	Use for Testing	Cuffs	-	Contamination		Out of Sequence		Part Moved
Internal Transport	Poor Information	Crushing	H	Countersink	<u> </u>	Off-set		Drawing
Tribal Knowledge	Rushing	Heat Treat	\Box	Cut Too Short	<u> </u>	Mislabeled	_	Finish
LOA	Product Improvement		-	Instructions Incomplete/	Unclear	Fit/Function	Г	Misread
Substation	Process Improvement		-	Drill Holes		Misaligned/off center		Turning Sequence

Past Due

Manufacturing Process

OTHER:

Past Expiry Date

Misidentified

List Lots

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Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
					Lot Code		
D407-667-205 Aft Crosstube - High 407	Main Warehouse FG	112865	5/5/2015	1.0000	QC21	CHG008	
	Main Warehouse FG	124541	5/5/2015	1.0000	QC21	CHG008	
	Main Warehouse FG	126504	5/5/2015	1.0000	QC21	CHG008	

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DQA:		Date:						
		_	WORK ORDER NON-	CONF	ORMANCE / UPI	DATE		AEROSPACE
QA Closed:		Date:				W	ork Order update only	
Work Order:			DISPOSITION			AGAINST DE	PARTMENT/PROCESS	
Part No.			Rework Scrap		Skid-tube Machining	Cross tube Small Fab	Water Jet Prod. Eng. Coor.	Quality
NCR No.			Use-as-is Suspected Unapproved	Th	nermoforming Large Fab	Finishing Composite	Rec/Store/Packaging Supplier	Other
Date :		Ste	ep #:		QTY Effective :			MRB (QSI042) Approval
	 	Description Work C	Order Deviation			Disposition		
								Completed By
				:				
						•		Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
	Root Ca	_				CATEGORY	1	_
Environment	 -	No Re-verfication	Pressure/Forced		perature/Cure	<u> </u>	Power Loss/Surge	Positioned Wrong
Design	\dashv \vdash	Operator	Bending	Set-	·		Folio/Program	Outside Dimensions
Doc/Data	\dashv \vdash	Offset/Setup	Centre Not Concentric		M/Route		Grain	Over/Under tolerance
Equip/Tooling	⊣	Supplier	Cracks		ken/Damage/Defect		Weld	Part Incorrect
Handling/Pre	_	Training	Crimp/Kink/Ripple/Wave	Insp	ection Incomplete/Unq	ualified	Wrong Stock Pulled	Part Lost/Missing
Material	_ _	Use for Testing	Cuffs	—	tamination		Out of Sequence	Part Moved
Internal Transport	_ -	Poor Information	Crushing	—	ntersink		Off-set	Drawing
Tribal Knowledge	_ _	Rushing	Heat Treat		Too Short	<u> </u>	Mislabeled	Finish
LOA	_ <u> </u>	Product Improvement	Wave/Twist in Tube		ructions Incomplete/Un	nclear	Fit/Function	Misread
Substation		Process Improvement	Marks/Chatter	Drill	Holes		Misaligned/off center	Turning Sequence
Past Expiry Date		Manufacturing Process						
Misidentified		Past Due	OTHER:					

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Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments	
0407-667-205RLC aft Crosstube - High 407	Main Warehouse FG093	124890	5/5/2015	1.0000	QC21	CHG008		
	Main Warehouse FG093	124891	5/5/2015	1.0000	QC21	CHG008		
			Total:	2.0000				

DQA:	Date:				TART
		WORK ORDER NON-C	ONFORMANCE / UPDATE		AEROSPACE
QA Closed:	Date:			Work Order update only	
Work Order:		DISPOSITION	AGAINS	T DEPARTMENT/PROCESS	
_		Rework	Skid-tube Cross tube	Water Jet	Engineering
Part No.		Scrap	Machining Small Fal		Quality
		Use-as-is	Thermoforming Finishing		
NCR No.		Suspected Unapproved	Large Fab Composite	Supplier	
Date :	Sto	ep #:	QTY Effective :		MRB (QSI042) Approval
_					
	Description Work (Order Deviation	Dispositi	on	
					Completed By
					Lead hand / Supervisor Approval Verification
					Approvar verification
					QC / QA Coordinator
					Approval
Ro	oot Cause	1	FAULT CATEGOR	Υ	
Environment	No Re-verfication	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld ∙	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	H wave, i wist iii i abe	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/ Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process	1 —,			
Misidentified	Past Due	OTHER:			

List Lots

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Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D407-667-205RLC Aft Crosstube - High 407	Main Warehouse FG093	124890	5/5/2015	1.0000	QC21	CHG008	
	Main Warehouse FG093	124891	5/5/2015	1.0000	QC21	CHG008	
			Total:	2.0000			

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DQA:	Date:					DART
QA Closed: Date:			I-CC	ONFORMANCE / UPDATE	AEROSPACE	
Work Order: DISPOSITION			AGAINST			
Part No.		Rework Scrap Use-as-is		Skid-tube Cross tube Machining Small Fab Thermoforming Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging	Engineering Quality Other
NCR No.		Suspected Unapproved	7 !	Large Fab Composite	Supplier	
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval
Description Work Order Deviation				Disposition		
		· · · · · · · · · · · · · · · · · · ·), 6 A (1977)	Completed By
	·					Lead hand / Supervisor Approval Verification
						QC / QA Coordinator Approval
Root Cause				FAULT CATEGORY		
Environment	No Re-verfication	Pressure/Forced		Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending		Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric		BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks		Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs		Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing		Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat		Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	wave/Twist in Tube		Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improveme	Marks/Chatter		Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Prod	ess				
Misidentified	Past Due	OTHER:				